

Work Order ID 144598

April 21, 2016 2:06:28 PM

144598

Page 1

Item ID: D2888

Accept

N900040100

Setup Start ***NS1***

Revision ID:

Stop ***NS2***

Item Name: Lug

Start Date: 4/27/2016 Start Qty: 10.00

10

Cust Item ID:

Required Date: 5/23/2016 Req'd Qty: 10.00

10

Customer:

Reference:

Approvals: Process Plan: MCS

Date: APR 22 2016

Tooling:

Date:

QC:

Date:

SPC (Y/N):

Date:

Run Start ***NR1***

Stop ***NR2***

Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Tool ID	Tool #	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
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Draw Nbr	Revision Nbr
D2888	Rev A2

100 0.00

100

Bandsaw

Memo

0.00

Jeaspa Bandsaw

Cut Blanks at 4.200" long
Grain along 4.200"

12 0 16/05/05

110

1.59

110

HAAS 1

Memo

4.50

HAAS CNC vertical machine #1

Machine as per Folio D2888

Folio Rev: AA

Dwg Rev: A

2-Deburr

12 0 16/05/06

DAS
44
9-89
16/05/07

P70

DQA:

Date: 16.05.27



WORK ORDER NON-CONFORMANCE / UPDATE

QA Closed:

Date: 16/05/20

Work Order update only ☐

Work Order: <u>144598</u> Part No. <u>D2888</u> NCR No. <u>16-5796</u>	DISPOSITION Rework ☐ Scrap ☐ Use-as-is ☒ Suspected Unapproved ☐	AGAINST DEPARTMENT/PROCESS <table style="width:100%;"> <tr> <td>Skid-tube ☐</td> <td>Cross tube ☐</td> <td>Water Jet ☐</td> <td>Engineering ☐</td> </tr> <tr> <td>Machining ☒</td> <td>Small Fab ☐</td> <td>Prod. Eng. Coord. ☐</td> <td>Quality ☐</td> </tr> <tr> <td>Thermoforming ☐</td> <td>Finishing ☐</td> <td>Rec/Store/Packaging ☐</td> <td>Other ☐</td> </tr> <tr> <td>Large Fab ☐</td> <td>Composite ☐</td> <td>Supplier ☐</td> <td></td> </tr> </table>			Skid-tube ☐	Cross tube ☐	Water Jet ☐	Engineering ☐	Machining ☒	Small Fab ☐	Prod. Eng. Coord. ☐	Quality ☐	Thermoforming ☐	Finishing ☐	Rec/Store/Packaging ☐	Other ☐	Large Fab ☐	Composite ☐	Supplier ☐																																																	
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Dimension 0.414 is up to 0.007 under tolerance		Acceptable based on test fit.		Completed By DAS 12 9-89 <u>16/5/6</u> Lead hand / Supervisor Approval Verification <u>PD</u> 16-05-18 QC / QA Coordinator Approval DAS 9 9-89 <u>16-05-18</u>																																																																
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Page 2

Hand Finishing

DQA: _____ Date: _____



WORK ORDER NON-CONFORMANCE / UPDATE

QA Closed: _____ Date: _____

Work Order update only ☐

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Page 3

Packaging

12 0 16-05-17 DAS 34 9.88

DAS
38
9-89

12 MAY 17 2016

12 **DAS** **MAY 18 2016**
6
9:40

DQA: _____ Date: _____



WORK ORDER NON-CONFORMANCE / UPDATE

QA Closed: _____ Date: _____

Work Order update only ☐

Work Order: _____ Part No. _____ NCR No. _____		DISPOSITION Rework ☐ Scrap ☐ Use-as-is ☐ Suspected Unapproved ☐		AGAINST DEPARTMENT/PROCESS Skid-tube ☐ Machining ☐ Thermoforming ☐ Large Fab ☐ Cross tube ☐ Small Fab ☐ Finishing ☐ Composite ☐ Water Jet ☐ Prod. Eng. Coord. ☐ Rec/Store/Packaging ☐ Supplier ☐ Engineering ☐ Quality ☐ Other ☐					
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Work Order ID 144598

April 21, 2016 2:06:28 PM

144598

Page 4

Item ID: D2888

Accept

N900040100Setup Start ***NS1***

Revision ID:

Stop ***NS2***

Item Name: Lug

Start Date: 4/27/2016 Start Qty: 10.00

10

Cust Item ID:

Required Date: 5/23/2016 Req'd Qty: 10.00

10

Customer:

Reference:

Approvals: Process Plan: _____ Date: _____ Tooling: _____ Date: _____

Run Start ***NR1***

QC: _____ Date: _____ SPC (Y/N): _____ Date: _____

Stop ***NR2***Sequence ID/
Work Center IDOperation
DescriptionSet Up/
Run Hours

Tool ID

Tool #

Plan
CodeAccept
QtyReject
QtyReject
NumberInsp.
Stamp

180

QC21 - Final Inspection - Work Order Release

0.00

180

QC

Memo

1.00

Quality Control

16/5/18 

MW MAY 18 2016

DQA: _____ Date: _____



WORK ORDER NON-CONFORMANCE / UPDATE

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OTHER : ☐																									

Picklist Print

April 21, 2016 2:06:28 PM

Work Order ID: 144598

144598

Parent Item: D2888

D2888

Parent Item Name: Lug

Start Date: 4/27/2016

Required

Start Qty: 10.00

Require

Comments: IPP C00.06.22Removed P/O for powder coatEC

Component Item ID/ Item Name	Replacement Item ID	Mfg/ Purch	Bin Item	Primary Location	Last Location	Route Seq ID	Unit of Measure	Qty on Hand	Qty per Kit	Total Qty	Qty Issued
M6061T6B2.500X03.50 0		Purchased		No		100	f	13.0090	0.39	3.9	

M6061T6B2 500X03 500

6061-T6 Bar 2.50 x 3.50

OSP
15/05/13

Location

Loc Qty

Loc Code

MAT004

13.009

m132772

0.3827

m133265

0.6263

m134158

12

4946'

DQA: _____ Date: _____



WORK ORDER NON-CONFORMANCE / UPDATE

QA Closed: _____ Date: _____

Work Order update only ☐

Work Order: _____ Part No. _____ NCR No. _____	DISPOSITION Rework ☐ Scrap ☐ Use-as-is ☐ Suspected Unapproved ☐	AGAINST DEPARTMENT/PROCESS <table style="width:100%; border: none;"> <tr> <td style="border: none;">Skid-tube ☐</td> <td style="border: none;">Cross tube ☐</td> <td style="border: none;">Water Jet ☐</td> <td style="border: none;">Engineering ☐</td> </tr> <tr> <td style="border: none;">Machining ☐</td> <td style="border: none;">Small Fab ☐</td> <td style="border: none;">Prod. Eng. Coord. ☐</td> <td style="border: none;">Quality ☐</td> </tr> <tr> <td style="border: none;">Thermoforming ☐</td> <td style="border: none;">Finishing ☐</td> <td style="border: none;">Rec/Store/Packaging ☐</td> <td style="border: none;">Other ☐</td> </tr> <tr> <td style="border: none;">Large Fab ☐</td> <td style="border: none;">Composite ☐</td> <td style="border: none;">Supplier ☐</td> <td></td> </tr> </table>				Skid-tube ☐	Cross tube ☐	Water Jet ☐	Engineering ☐	Machining ☐	Small Fab ☐	Prod. Eng. Coord. ☐	Quality ☐	Thermoforming ☐	Finishing ☐	Rec/Store/Packaging ☐	Other ☐	Large Fab ☐	Composite ☐	Supplier ☐																																																									
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DART AEROSPACE LTD		Work Order:	144598
Description: Lug		Part Number:	D2888
Inspection Dwg: D2888		Rev: A2	Page 1 of 1

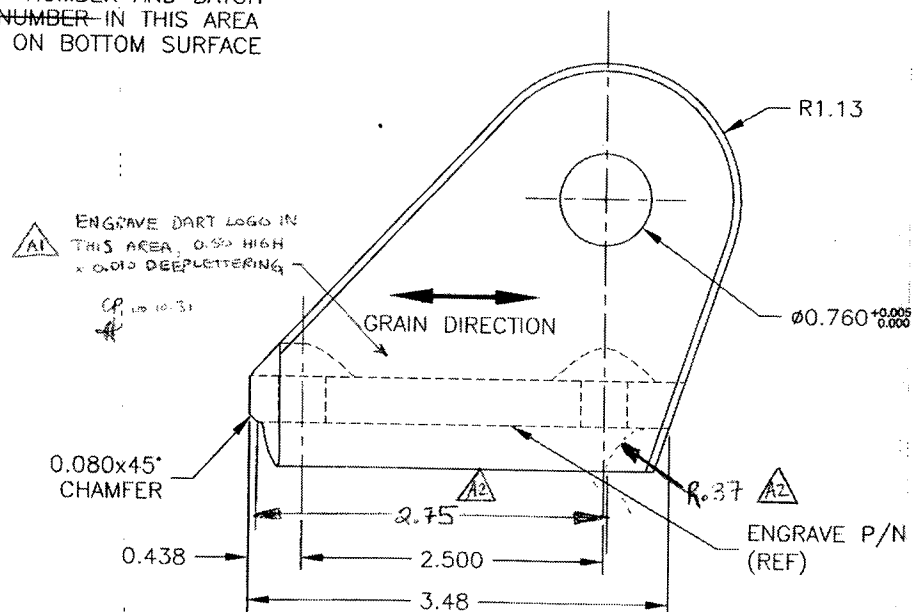
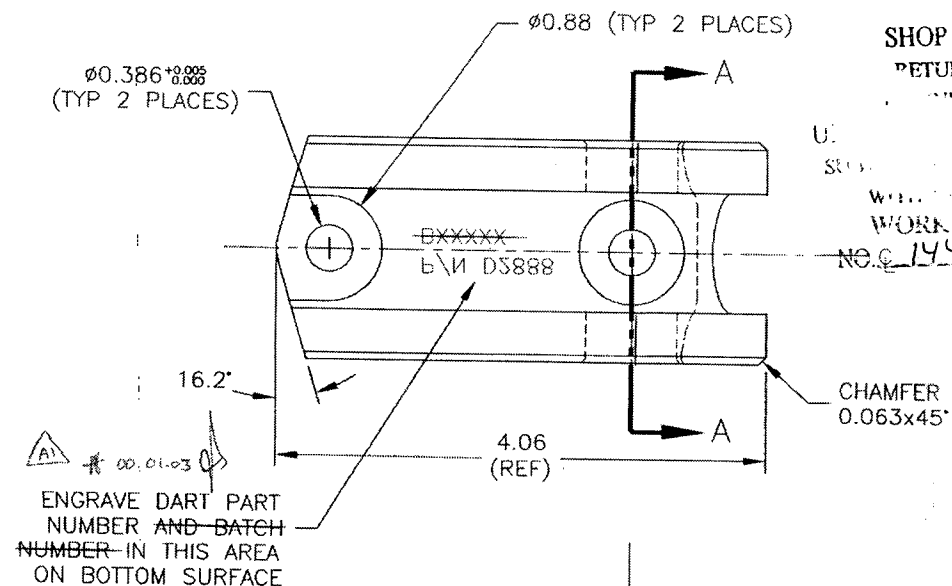
FIRST ARTICLE INSPECTION CHECKLIST

☒ First Article ☐ Prototype

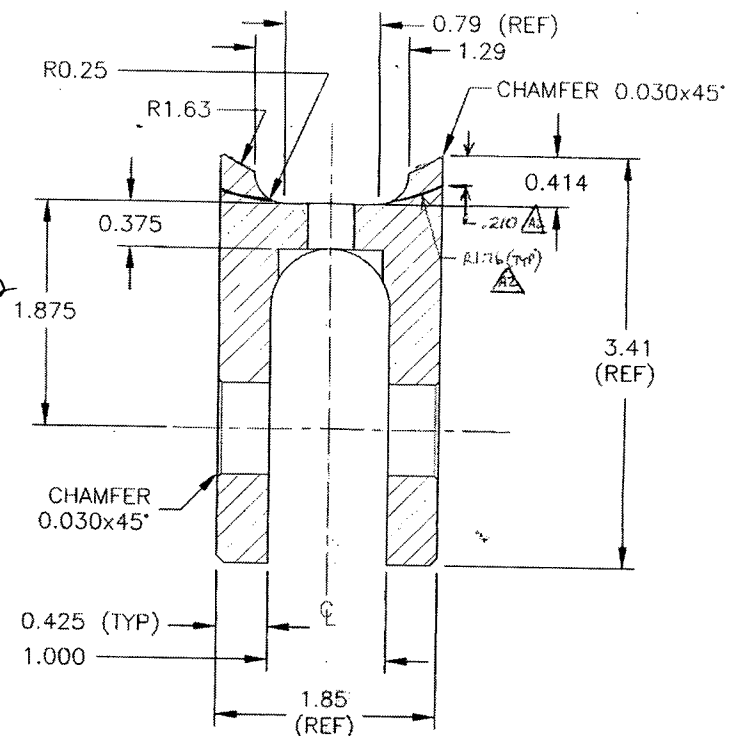
Drawing Dimension	Tolerance	Actual Dimension	Accept	Reject	Method of Inspection	Comments
Ø0.386	+0.005/-0.000	0,388	✓		MIP-04	✓
Ø0.88	+/-0.030	0,875	✓		↓	↓
0.063 x 45°	+/-0.010	0,062	✓		↓	↓
4.06	+/-0.030	4,061	✓		31006	Height gauge
Ø0.760	+0.005/-0.000	0,7605	✓		—	gauge pin
3.48	+/-0.030	3,480	✓		MIP-04	✓
2.500	+/-0.010	2,500	✓		↓	↓
2.75	+/-0.030	2,750	✓			
0.438	+/-0.010	0,437	✓			
0.080 x 45°	+/-0.010	0,080 x 45°	✓			
1.85	+/-0.030	1,848	✓			
1.000	+/-0.010	1,002	✓			
0.425	+/-0.010	0,422	✓			
0.030 x 45°	+/-0.010	0,030 x 45°	✓			
1.875	+/-0.010	1,875	✓			
0.375	+/-0.010	0,377	✓		↓	↓
R0.25	+/-0.030	0,250	✓		—	Radius gauge
1.29	+/-0.030	1,285	✓		31006	Height gauge
0.414	+/-0.010	0,407	✓		↓	↓
3.41	+/-0.030	3,396	✓		↓	↓

Measured by:	<i>[Signature]</i>	Audited by:	<i>[Signature]</i>	DAS	Prototype Approval:	N/A
Date:	16/05/06	Date:	16/05/08	08 9-89	Date:	N/A

Rev	Date	Change	Revised by	Approved
A	08.06.04	New Issue	KJ/DD	<i>[Signature]</i>



SHOP COPY
 RETURN TO
 DART AEROSPACE LTD
 16-0422



SECTION A-A
 SCALE 1:1

RELEASED
 99.07.09 DS

MATERIAL: 6061-T6 (QQ-A-200/8 OR QQ-A-250/11 OR QQ-A-225/8)
 FINISH: ACID ETCH AND ALODINE PER DART QSI 005 4.1
 POWDER COAT WHITE (4.3.5.1) PER DART QSI 005 4.3
 BREAK UNMARKED EDGES 0.010 TO 0.020
 TOLERANCES ARE PER DART QSI 018 UNLESS OTHERWISE NOTED

A2	04.04.08	Add Saddle Clearance for NCR 754	99.06.21	NEW ISSUE
A1	00.10.31	Update Engineering	99.06.21	
DESIGN		DRAWN BY	UP	DART DART AEROSPACE LTD HARRISBURY, ONTARIO, CANADA
CHECKED		APPROVED	AE	DRAWING NO. D2888
DATE		TITLE		REV. A SHEET 1 OF 1
		LUG		SCALE 1:1